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SECTION 03101

FORMWORK FOR CONCRETE

PART 1 GENERAL

1.1 REFERENCES

The publications listed below form a part of this specification to the extent referenced. The publications are referred to in the text by basic designation only.

ACI INTERNATIONAL (ACI)

ACI 347R (1994) Guide for Formwork for Concrete

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM C 31 (1994) Making and Curing Concrete Test Specimens in the Field

ASTM C 39 (1993a) Compressive Strength of Cylindrical Concrete Specimens

ASTM C 1077 (1995a) Laboratories Testing Concrete and Concrete Aggregates for Use in Construction and Criteria for Laboratory Evaluation

DEPARTMENT OF COMMERCE (DOC)

DOC PS 1 (1983) Construction and Industrial Plywood

1.2 DESIGN REQUIREMENTS

The design, engineering, and construction of the formwork shall be the responsibility of the Contractor. The formwork shall be designed for anticipated live load and dead load, lateral pressure, and allowable stresses in accordance with Chapter 1 of ACI Standard 347. Forms shall have sufficient strength to withstand the pressure resulting from placement and vibration of the concrete and shall have sufficient rigidity to maintain specified tolerances. However, for surfaces with an ACI Class A surface designation, the allowable deflection for facing material between studs, for studs between walers and walers between bracing shall be limited to 0.0025 times the span. The formwork shall be designed as a complete system with consideration given to the effects of cementitious materials and mixture additives such as fly ash, cement type, accelerators, retarders, air entrainment, and others. The adequacy of formwork design and construction shall be monitored prior to and during concrete placement as part of the Contractor's approved Quality Control Plan.

1.3 SUBMITTALS

Government approval is required for submittals with a "GA" designation; submittals having an "FIO" designation are for information only. The following shall be submitted in accordance with Section 01330 SUBMITTAL PROCEDURES:

SD-09 Reports

Inspection; FIO .

Inspection results of forms and embedded items

PART 2 PRODUCTS

2.1 MATERIALS

2.1.1 Forms and Form Liners

Forms and form liners shall be fabricated with facing materials that will produce a finish meeting the specified construction tolerance requirements and the following surface classifications as defined in ACI 347R, and as adjusted in Section 03307 CAST-IN-PLACE STRUCTURAL CONCRETE.

2.1.1.1 Class "A" Finish

This class of finish shall apply to all concrete which will be exposed to flowing water during the structure's life. The form facing material shall be composed of new, well-matched tongue-and-groove lumber or new plywood panels conforming to DOC PS 1, Grade B-B concrete form, Class I.

2.1.1.2 Class "D" Finish

This class of finish shall apply to concrete faces against which earthfill will be placed. The form facing may be of wood or steel.

2.1.2 Form Coating

Form coating shall be commercial formulation that will not bond with, stain, cause deterioration, or any other damage to concrete surfaces. The coating shall not impair subsequent treatment of concrete surfaces depending upon bond or adhesion nor impede the wetting of surfaces to be cured with water or curing compounds. If special form liners are to be used, the Contractor shall follow the recommendation of the form coating manufacturer.

2.2 ACCESSORIES

Ties and other similar form accessories to be partially or wholly embedded in the concrete shall be of a commercially manufactured type. After the ends or end fasteners have been removed, the embedded portion of metal ties shall terminate not less than 2 inches from any concrete surface either

exposed to view or exposed to water. Plastic snap ties may be used in locations where the surface will not be exposed to view. Form ties shall be constructed so that the ends or end fasteners can be removed without spalling the concrete.

PART 3 EXECUTION

3.1 INSTALLATION

3.1.1 Form Construction

Forms shall be constructed true to the structural design and required alignment. The form surface and joints shall be mortar tight and supported to achieve safe performance during construction, concrete placement, and form removal. The Contractor shall continuously monitor the alignment and stability of the forms during all phases to assure the finished product will meet the required surface class. Failure of any supporting surface either due to surface texture, deflection or form collapse shall be the responsibility of the Contractor as will the replacement or correction of unsatisfactory surfaces. When forms for continuous surfaces are placed in successive units, care shall be taken to fit the forms over the completed surface to obtain accurate alignment of the surface and to prevent leakage of mortar. Forms shall not be re-used if there is any evidence of defects which would impair the quality of the resulting concrete surface. All surfaces of used forms shall be cleaned of mortar and any other foreign material before reuse.

3.1.2 Chamfering

All exposed joints, edges and external corners shall be chamfered by molding placed in the forms unless the drawings specifically state that chamfering is to be omitted or as otherwise specified. Chamfered joints shall not be permitted where earth or rockfill is placed in contact with concrete surfaces. Chamfered joints shall be terminated twelve inches outside the limit of the earth or rockfill so that the end of the chamfers will be clearly visible.

3.1.3 Coating

Forms for exposed or painted surfaces shall be coated with form oil or a form-release agent before the form or reinforcement is placed in final position. The coating shall be used as recommended in the manufacturer's instructions. Forms for unexposed surfaces may be wet with water in lieu of coating immediately before placing concrete, except that, in cold weather when freezing temperatures are anticipated, coating shall be mandatory. Surplus coating on form surfaces and coating on reinforcing steel and construction joints shall be removed before placing concrete.

3.2 FORM REMOVAL

Forms shall not be removed without approval. The minimal time required for concrete to reach a strength adequate for removal of formwork without risking the safety of workers or the quality of the concrete depends on a number of factors including, but not limited to, ambient temperature,

concrete lift heights, type and amount of concrete admixture, and type and amount of cementitious material in the concrete. It is the responsibility of the Contractor to consider all applicable factors and leave the forms in place until it is safe to remove them. In any case forms shall not be removed unless the minimum compressive strength requirements below are met, except as otherwise directed or specifically authorized. When conditions are such as to justify the requirement, forms will be required to remain in place for a longer period. All removal shall be accomplished in a manner which will prevent damage to the concrete and ensure the complete safety of the structure. Where forms support more than one element, the forms shall not be removed until the form removal criteria are met by all supported elements. Form removal shall be scheduled so that all necessary repairs can be performed as specified in Section 03307 CAST-IN-PLACE STRUCTURAL CONCRETE, paragraph FORMED SURFACES. Evidence that concrete has gained sufficient strength to permit removal of forms shall be determined by tests on control cylinders. All control cylinders shall be stored in the structure or as near the structure as possible so they receive the same curing conditions and protection methods as given those portions of the structure they represent. Control cylinders shall be removed from the molds at an age of no more than 24 hours. All control cylinders shall be prepared and tested in accordance with ASTM C 31 and ASTM C 39 at the expense of the Contractor by an independent laboratory that complies with ASTM C 1077 and shall be tested within 4 hours after removal from the site.

3.2.1 Formwork Not Supporting Weight of Concrete

Formwork for gravity structures and other vertical type formwork not supporting the weight of concrete shall not be removed in less than 24 hours after concrete placement is completed. The stability of the concrete shall be evaluated by a structural engineer prior to removal of the forms.

3.2.2 Formwork Supporting Weight of Concrete

Formwork supporting weight of concrete and shoring shall not be removed until structural members have acquired sufficient strength to safely support their own weight and any construction or other superimposed loads to which the supported concrete may be subjected. As a minimum, forms shall be left in place until control concrete test cylinders indicate evidence the concrete has attained at least 70 percent of the compressive strength required for the structure in accordance with the quality and location requirements of Section 03307 CAST-IN-PLACE STRUCTURAL CONCRETE, paragraph REQUIRED AVERAGE COMPRESSIVE STRENGTH.

3.3 INSPECTION

Forms and embedded items shall be inspected in sufficient time prior to each concrete placement by the Contractor in order to certify to the Contracting Officer that they are ready to receive concrete. The results of each inspection shall be reported in writing.

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SECTION 03200

CONCRETE REINFORCEMENT

PART 1 GENERAL

1.1 REFERENCES

The publications listed below form a part of this specification to the extent referenced. The publications are referred to in the text by basic designation only.

ACI INTERNATIONAL (ACI)

ACI 318/318R (1995) Building Code Requirements for
Structural Concrete and Commentary

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM A 615 (1996a) Deformed and Plain Billet-Steel
Bars for Concrete Reinforcement

CONCRETE REINFORCING STEEL INSTITUTE (CRSI)

CRSI MSP-1 (1996) Manual of Standard Practice

PART 2 PRODUCTS

2.1 REINFORCING STEEL

Reinforcing steel shall be deformed bars conforming to ASTM A 615 grades and sizes as indicated at drawings.

2.2 WIRE TIES

Wire ties shall be 16 gauge or heavier black annealed steel wire.

2.3 SUPPORTS

Bar supports for formed surfaces shall be designed and fabricated in accordance with CRSI MSP-1 and shall be steel or precast concrete blocks. Precast concrete blocks shall have wire ties and shall be not less than 4 inches square when supporting reinforcement on ground. Precast concrete block shall have compressive strength equal to that of the surrounding concrete. Where concrete formed surfaces will be exposed to weather or where surfaces are to be painted, steel supports within 1/2 inch of concrete surface shall be galvanized, plastic protected or of stainless steel. Concrete supports used in concrete exposed to view shall have the same color and texture as the finish surface. For slabs on grade, supports shall be precast concrete blocks, plastic coated steel fabricated with bearing plates, or specifically designed wire-fabric supports fabricated of plastic.

PART 3 EXECUTION

3.1 REINFORCEMENT

Reinforcement, steel and accessories shall be fabricated to shapes and dimensions shown and shall conform to the requirements of ACI 318/318R. Reinforcement shall be cold bent unless otherwise authorized. Bending may be accomplished in the field or at the mill. Bars shall not be bent after embedment in concrete. Safety caps shall be placed on all exposed ends of vertical concrete reinforcement bars that pose a danger to life safety. Wire tie ends shall face away from the forms.

3.1.1 Placement

Reinforcement shall be free from loose rust and scale, dirt, oil, or other deleterious coating that could reduce bond with the concrete. Reinforcement shall be placed in accordance with ACI 318/318R at locations shown plus or minus one bar diameter. Concrete coverage shall be as indicated or as required by ACI 318/318R. If bars are moved more than one bar diameter to avoid interference with other reinforcement, conduits or embedded items, the resulting arrangement of bars, including additional bars required to meet structural requirements, shall be approved before concrete is placed.

3.1.2 Splicing

Splices of reinforcement shall conform to ACI 318/318R and shall be made only as required or indicated. Splicing shall be by lapping or by mechanical ; except that lap splices shall not be used for bars larger than No. 11 unless otherwise indicated.

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SECTION 03307

CONCRETE FOR MINOR STRUCTURES AND GROUTING STONE

PART 1 GENERAL

1.1 REFERENCES

The publications listed below form a part of this specification to the extent referenced. The publications are referred to in the text by basic designation only.

ACI INTERNATIONAL (ACI)

ACI 308 (1992) Standard Practice for Curing Concrete

ACI 347R (1994) Formwork for Concrete

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM C 31 (1994) Making and Curing Concrete Test Specimens in the Field

ASTM C 33 (1993) Concrete Aggregates

ASTM C 39 (1993a) Compressive Strength of Cylindrical Concrete Specimens

ASTM C 94 (1998) Ready-Mixed Concrete

ASTM C 143 (1990a) Slump of Hydraulic Cement Concrete

ASTM C 150 (1995) Portland Cement

ASTM C 172 (1990) Sampling Freshly Mixed Concrete

ASTM C 231 (1997) Air Content of Freshly Mixed Concrete by the Pressure Method

ASTM C 260 (1994) Air-Entraining Admixtures for Concrete

ASTM C 309 (1993) Liquid Membrane-Forming Compound for Curing Concrete.

ASTM C 618 (1994a) Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use as a Mineral

Admixture in Portland Cement Concrete

ASTM C 685 (1994) Concrete Made by Volumetric
Batching and Continuous Mixing

ASTM D 75 (1987; R 1992) Sampling Aggregates

CORPS OF ENGINEERS (COE)

COE CRD-C 400 (1963) Requirements for Water for Use in
Mixing or Curing Concrete

1.2 DESIGN AND PERFORMANCE REQUIREMENTS

The Government will maintain the option to sample and test aggregates and concrete to determine compliance with the specifications. The Contractor shall provide facilities and labor as may be necessary to assist the Government in procurement of representative test samples. Samples of aggregates will be obtained at the point of batching in accordance with ASTM D 75. Concrete will be sampled in accordance with ASTM C 172. Slump and air content will be determined in accordance with ASTM C 143 and ASTM C 231, respectively, when cylinders are molded. Compression test specimens will be made, cured, and transported in accordance with ASTM C 31. Compression test specimens will be tested in accordance with ASTM C 39. Samples for strength tests will be taken not less than once each shift in which concrete is produced. A minimum of three specimens will be made from each sample; two will be tested at 28 days for acceptance, and one will be tested at 7 days for information.

1.2.1 Strength

Acceptance test results will be the average strengths of two specimens tested at 28 days. The strength of the concrete will be considered satisfactory so long as the average of three consecutive acceptance test results equal or exceed the specified compressive strength, f'_c , and no individual acceptance test result falls below f'_c by more than 500 psi.

1.2.2 Construction Tolerances

A Class "C" finish shall apply to all surfaces except those specified to receive a Class "D" finish. A Class "D" finish shall apply to all surfaces which will be permanently concealed after construction. The surface requirements for the classes of finish required shall be as specified in ACI 347R.

1.2.3 Concrete Mixture Proportions

Concrete mixture proportions shall be the responsibility of the Contractor. Mixture proportions shall include the dry weights of cementitious

material(s); the nominal maximum size of the coarse aggregate; the specific gravities, absorptions, and saturated surface-dry weights of fine and coarse aggregates; the quantities, types, and names of admixtures; and quantity of water per cubic yard of concrete. All materials included in the mixture proportions shall be of the same type and from the same source as will be used on the project. Specified compressive strength f'c shall be 3,000 psi at 28 days. The maximum nominal size coarse aggregate shall be 3/4 inch, in accordance with ACI 318/318R. The air content shall be between 4 and 5 percent. The slump shall be between 2 and 5 inches. The maximum water cement ratio shall be 0.50.

1.3 SUBMITTALS

Government approval is required for all submittals with a "GA" designation; submittals having an "FIO" designation are for information only. The following shall be submitted in accordance with Section 01330 SUBMITTAL PROCEDURES:

SD-01 Data

Air-Entraining Admixture; FIO. Accelerating Admixture; FIO. Curing Materials; FIO.

Manufacturer's literature is available from suppliers which demonstrates compliance with applicable specifications for the above materials.

Batching and Mixing Equipment; FIO.

Batching and mixing equipment will be accepted on the basis of manufacturer's data which demonstrates compliance with the applicable specifications.

Conveying and Placing Concrete; FIO.

The methods and equipment for transporting, handling, depositing, and consolidating the concrete shall be submitted prior to the first concrete placement.

SD-08 Statements

Formwork; FIO.

Formwork design shall be submitted prior to the first concrete placement.

SD-09 Reports

Aggregates; FIO.

Aggregates will be accepted on the basis of certificates of compliance and test reports that show the material(s) meets the quality and grading requirements of the specifications under which it is furnished.

Concrete Mixture Proportions; FIO.

Grout Mixture Proportions; FIO.

Ten days prior to placement of concrete or grout, the contractor shall submit the mixture proportions that will produce concrete of the quality required. Applicable test reports shall be submitted to verify that the concrete mixture proportions selected will produce concrete of the quality specified.

SD-13 Certificates

Cementitious Materials; FIO.

Certificates of compliance attesting that the concrete materials meet the requirements of the specifications shall be submitted in accordance with the Special Clause "CERTIFICATES OF COMPLIANCE". Cementitious material will be accepted on the basis of a manufacturer's certificate of compliance, accompanied by mill test reports that the material(s) meet the requirements of the specification under which it is furnished.

Aggregates; FIO.

Aggregates will be accepted on the basis of certificates of compliance and tests reports that show the material(s) meet the quality and grading requirements of the specifications under which it is furnished.

PART 2 PRODUCTS

2.1 MATERIALS

2.1.1 Cementitious Materials

Cementitious materials shall conform to the appropriate specifications listed:

2.1.1.1 Portland Cement

ASTM C 150, Type II, including false set requirements and low alkali. The alkali content for grouting stone shall not exceed 0.6 percent

2.1.1.2 Pozzolan

Pozzolan shall conform to ASTM C 618, Class F with loss on ignition limited to 6 percent.

2.1.2 Aggregates

Aggregates shall meet the quality and grading requirements of ASTM C 33 Class Designations 4M or better.

2.1.3 Admixtures

Admixtures to be used, when required or approved, shall comply with the appropriate specification listed.

2.1.3.1 Air-Entraining Admixture

Air-entraining admixture shall meet the requirements of ASTM C 260.

2.1.4 Water

Water for mixing and curing shall be fresh, clean, potable, and free from injurious amounts of oil, acid, salt, or alkali, except that unpotable water may be used if it meets the requirements of COE CRD-C 400.

2.1.5 Curing Materials

Curing materials shall conform to the following requirements.

2.1.5.1 Membrane-Forming Curing Compound

Membrane curing compound shall conform to ASTM C 309, Type 1-D with fugitive dye.

PART 3 EXECUTION

3.1 PREPARATION

3.1.1 General

Snow, ice, standing or flowing water, loose particles, debris, and foreign matter shall have been removed. Earth foundations shall be satisfactorily compacted. Spare vibrators shall be available. The entire preparation shall be accepted by the Government prior to placing.

3.1.2 Embedded Items

Reinforcement shall be secured in place; joints, anchors, and other embedded items shall have been positioned. Internal ties shall be arranged so that when the forms are removed all metal will be not less than 2 inches from concrete surfaces permanently exposed to view or exposed to water on the finished structures. Embedded items shall be free of oil and other foreign matters such as loose coatings or rust, paint, and scale. The embedding of wood in concrete will be permitted only when specifically authorized or directed. All equipment needed to place, consolidate, protect, and cure the concrete shall be at the placement site and in good operating condition.

3.1.3 Formwork Installation

Forms shall be properly aligned, adequately supported, and mortar-tight. The form surfaces shall be smooth and free from irregularities, dents, sags, or holes when used for permanently exposed faces. All exposed joints and edges shall be chamfered, unless otherwise indicated.

3.1.4 Concrete on Earth Foundations

Earth (subgrade, base, or subbase courses) surfaces upon which concrete is

to be placed shall be clean, damp, and free from debris, frost, ice, and standing or running water. Prior to placement of concrete, the foundation shall be well drained and shall be satisfactorily graded and uniformly compacted

3.1.5 Production of Concrete

3.1.5.1 Ready-Mixed Concrete

Ready-mixed concrete shall conform to ASTM C 94 except as otherwise specified.

3.1.5.2 Concrete Made by Volumetric Batching and Continuous Mixing

Concrete made by volumetric batching and continuous mixing shall conform to ASTM C 685.

3.1.5.3 Batching and Mixing Equipment

The contractor shall have the option of using an on-site batching and mixing facility. The facility shall provide sufficient batching and mixing equipment capacity to prevent cold joints.

3.1.6 Construction Joints

For concrete other than slabs on grade, construction joints shall be as indicated. Concrete shall be placed continuously so that each unit is monolithic in construction. Fresh concrete shall not be placed against adjacent hardened concrete until it is at least 24 hours old. Construction joints shall be located as indicated or approved. Where concrete work is interrupted by weather, end of work shift or other similar type of delay, location and type of construction joint shall be subject to approval of the Contracting Officer. Unless otherwise indicated and except for slabs on grade, reinforcing steel shall extend through construction joints. Construction joints in slabs on grade shall be keyed or doweled as shown. Concrete columns, walls, or piers shall be in place at least 2 hours, or until the concrete begins to lose its plasticity, before placing concrete for beams, girders, or slabs thereon. In walls having door or window openings, lifts shall terminate at the top and bottom of the opening. Other lifts shall terminate at such levels as to conform to structural requirements or architectural details. Where horizontal construction joints in walls or columns are required, a strip of 25 mm (1 inch) square-edge lumber, bevelled and oiled to facilitate removal, shall be tacked to the inside of the forms at the construction joint. Concrete shall be placed to a point 25 mm (1 inch) above the underside of the strip. The strip shall be removed 1 hour after the concrete has been placed, and any irregularities in the joint line shall be leveled off with a wood float, and all laitance shall be removed. Prior to placing additional concrete, horizontal construction joints shall be prepared as specified in paragraph Previously Placed Concrete.

3.2 CONVEYING AND PLACING CONCRETE

Conveying and placing concrete shall conform to the following requirements.

3.2.1 General

Concrete placement shall not be permitted when weather conditions prevent proper placement and consolidation without approval. When concrete is mixed and/or transported by a truck mixer, the concrete shall be delivered to the site of the work and discharge shall be completed within 1-1/2 hours or 45 minutes when the placing temperature is 85 degrees F or greater unless a retarding admixture is used. Concrete shall be conveyed from the mixer to the forms as rapidly as practicable by methods which prevent segregation or loss of ingredients. Concrete shall be in place and consolidated within 15 minutes after discharge from the mixer. Concrete shall be deposited as close as possible to its final position in the forms and be so regulated that it may be effectively consolidated in horizontal layers 18 inches or less in thickness with a minimum of lateral movement. The placement shall be carried on at such a rate that the formation of cold joints will be prevented.

3.2.2 Consolidation

Each layer of concrete shall be consolidated by rodding, spading, or internal vibrating equipment. Internal vibration shall be systematically accomplished by inserting the vibrator through the fresh concrete in the layer below at a uniform spacing over the entire area of placement. The distance between insertions shall be approximately 1.5 times the radius of action of the vibrator and overlay the adjacent, just-vibrated area by a few inches. The vibrator shall penetrate rapidly to the bottom of the layer and at least 6 inches into the layer below, if such a layer exists. It shall be held stationary until the concrete is consolidated and then withdrawn slowly at the rate of about 3 inches per second.

3.2.3 Cold-Weather Requirements

No concrete placement shall be made when the ambient temperature is below 35 degrees F or if the ambient temperature is below 40 degrees F and falling. Suitable covering and other means as approved shall be provided for maintaining the concrete at a temperature of at least 50 degrees F for not less than 72 hours after placing and at a temperature above freezing for the remainder of the curing period. Salt, chemicals, or other foreign materials shall not be mixed with the concrete to prevent freezing. Any concrete damaged by freezing shall be removed and replaced at the expense of the contractor.

3.2.4 Hot-Weather Requirements

When the rate of evaporation of surface moisture, as determined by use of Figure 1 of ACI 308, is expected to exceed 0.2 pound per square foot per hour, provisions for windbreaks, shading, fog spraying, or covering with a light-colored material shall be made in advance of placement, and such protective measures shall be taken as quickly as finishing operations will allow.

3.3 FINISHING

3.3.1 General

No finishing or repair will be done when either the concrete or the ambient temperature is below 50 degrees F.

3.3.2 Finishing Formed Surfaces

All fins and loose materials shall be removed, and surface defects including tie holes shall be filled. All honeycomb areas and other defects shall be repaired. All unsound concrete shall be removed from areas to be repaired. Surface defects greater than 1/2 inch in diameter and holes left by removal of tie rods in all surfaces not to receive additional concrete shall be reamed or chipped and filled with dry-pack mortar. The prepared area shall be brush-coated with an approved epoxy resin or latex bonding compound or with a neat cement grout after dampening and filled with mortar or concrete. The cement used in mortar or concrete for repairs to all surfaces permanently exposed to view shall be a blend of portland cement and white cement so that the final color when cured will be the same as adjacent concrete.

3.3.3 Finishing Unformed Surfaces

All unformed surfaces that are not to be covered by additional concrete or backfill shall be float finished to elevations shown, unless otherwise specified. Surfaces to receive additional concrete or backfill shall be brought to the elevations shown and left as a true and regular surface. Exterior surfaces shall be sloped for drainage unless otherwise shown. Joints shall be carefully made with a jointing tool. Unformed surfaces shall be finished to a tolerance of 3/8 inch for a float finish and 5/16 inch for a trowel finish as determined by a 10 foot straightedge placed on surfaces shown on the plans to be level or having a constant slope. Finishing shall not be performed while there is excess moisture or bleeding water on the surface. No water or cement shall be added to the surface during finishing.

3.3.3.1 Float Finish

Surfaces to be float finished shall be screeded and darbied or bullfloated to eliminate the ridges and to fill in the voids left by the screed. In addition, the darby or bullfloat shall fill all surface voids and only slightly embed the coarse aggregate below the surface of the fresh concrete. When the water sheen disappears and the concrete will support a person's weight without deep imprint, floating should be completed. Floating should embed large aggregates just beneath the surface, remove slight imperfections, humps, and voids to produce a plane surface, compact the concrete, and consolidate mortar at the surface.

3.3.3.2 Trowel Finish

A trowel finish shall be applied to top of structure. Trowelling shall be done immediately to provide a smooth, even, dense finish free from blemishes including trowel marks. Finished surfaces shall be protected from damage during the construction period.

3.4 GROUTING STONE

3.4.1 Mixing

Grout shall be composed of cement, sand, and water mixed in the proportions as directed. The estimated cement content requirement per cubic yard of grout shall be 7-1/2 sacks. The water content of the mix shall not exceed 8-1/2 gallons per sack of cement. In calculating total water content of the mix, the amount of moisture carried on the surface of aggregate particles shall be included. Slump of grout mix shall be between 7 to 8 inches. The grout shall be mixed in a concrete mixer in the manner specified for concrete, except that time of mixing shall be as long as is required to produce a satisfactory mixture, and the grout shall be used in the work within a period of 30 minutes after mixing. Retempering of grout will not be permitted. The consistency of the grout shall be such as a permit gravity flow into the interstices of the stones with the help of spading, rodding, and brooming. Grout batches in the same course shall be uniform in mix, size, and consistency.

3.4.2 Grout Placement

Prior to grouting, the stone shall be thoroughly washed with water, to wash down fines and to prevent absorption of water from the grout. The stone shall be kept wet just ahead of actual grout placement. The grout shall be placed in one course. The course shall be placed the full width. The grout shall be brought to the place of final-deposit by approved means and discharged directly on the stone. A splash plate of metal or wood shall be used where necessary to prevent displacement of stone directly under discharge. The flow of grout into the stone voids shall be controlled by the grout operator to assure that all voids are adequately penetrated. When necessary, grout shall be directed with brooms or other approved baffles to cover the entire area and stone voids. Sufficient barring shall be done to loosen tight pockets of stone and otherwise aid the penetration of grout. The course shall fully penetrate the stone blanket. Placement and brooming of the grouted surface shall be such that the outer layer of rock projects 1/3 to 1/4 their diameter above the grouted surface.

3.5 CURING AND PROTECTION

Beginning immediately after placement and continuing for at least 7 days, all concrete and grouted stone shall be cured and protected from premature drying, extremes in temperature, rapid temperature change, freezing, mechanical damage, and exposure to rain or flowing water. All materials and equipment needed for adequate curing and protection shall be available and at the site of the placement prior to the start of concrete placement. Preservation of moisture for concrete surfaces not in contact with forms shall be accomplished by application of membrane-forming curing compound conforming to ASTM C 309, Type 1-D, on surfaces permanently exposed to view and Type 2 on other surfaces shall be accomplished in accordance with manufacturer's instructions. Curing of grouted stone shall be performed by moist curing with a uniform 2 inch thick blanket of sand over the grout continuously saturated for 14 days, or by curing compounds or by membrane forming curing compound as described above

3.6 TESTS AND INSPECTIONS

3.6.1 General

The individuals who sample and test concrete as required in this specification shall have demonstrated a knowledge and ability to perform the necessary test procedures equivalent to the ACI minimum guidelines for certification of Concrete Field Testing Technicians, Grade I.

3.6.2 Inspection Details and Frequency of Testing

3.6.2.1 Preparations for Placing

Foundation or construction joints, forms, and embedded items shall be inspected in sufficient time prior to each concrete placement by the Contractor to certify that it is ready to receive concrete.

3.6.2.2 Air Content

Air content shall be checked at least once during each shift that concrete is placed. Samples shall be obtained in accordance with ASTM C 172 and tested in accordance with ASTM C 231.

3.6.2.3 Slump

Slump shall be checked once during each shift that concrete is produced. Samples shall be obtained in accordance with ASTM C 172 and tested in accordance with ASTM C 143.

3.6.2.4 Consolidation and Protection

The Contractor shall ensure that the concrete is properly consolidated, finished, protected, and cured.

3.6.3 Action Required

3.6.3.1 Placing

The placing foreman shall not permit placing to begin until he has verified that an adequate number of acceptable vibrators, which are in working order and have competent operators, are available. Placing shall not be continued if any pile is inadequately consolidated.

3.6.3.2 Air Content

Whenever a test result is outside the specification limits, the concrete shall not be delivered to the forms and an adjustment shall be made to the dosage of the air-entrainment admixture.

3.6.3.3 Slump

Whenever a test result is outside the specification limits, the concrete shall not be delivered to the forms and an adjustment should be made in the

batch weights of water and fine aggregate. The adjustments are to be made so that the water-cement ratio does not exceed that specified in the submitted concrete mixture proportion.

3.6.4 Reports

The results of all tests and inspections conducted at the project site shall be reported informally at the end of each shift and in writing weekly and shall be delivered within 3 days after the end of each weekly reporting period. See Section 01440 CONTRACTOR QUALITY CONTROL.

-- End of Section --